

WHAT IS CLAIMED IS:

1. A method for manufacturing molten iron, comprising the steps of:
producing reducing material of mixed hot fine direct reduced iron and
calcined additives, the reducing material being produced from multiple
5 fluidized beds;
charging the reducing material to at least one pair of roller presses;
roll pressing the reducing material through the one pair of roller
presses to produce continuous compacted material having grooves formed
on pressed surfaces;
10 crushing the compacted material;
charging the crushed compacted material to a coal packed bed; and
supplying oxygen to the coal packed bed to manufacture molten iron,
wherein in the producing compacted material, the compacted
material is formed such that acute and obtuse angles are formed between a
15 center line formed along a length of a cross section that is cut along a
lengthwise direction perpendicular to an axial direction of the roller presses
and connecting lines that connect grooves closest to each other across the
cross sectional area.
2. The method of claim 1, wherein the step of charging the reducing
20 material comprises charging the reducing material in two slanted directions
at acute angles to a direction perpendicular to the roller presses.
3. The method of claim 1, wherein in the step of producing the
compacted material, the produced compacted material has a thickness of
3~30 mm and a density of 3.5~4.2 tons/m³.
- 25 4. The method of claim 1, wherein in the step of crushing the
compacted material, an average grain size of the compacted material is 50
mm or less, and the crushing performed produces irregular shapes.
5. The method of claim 1, further comprising the steps of:
bypassing the crushed compacted material;
30 cooling the bypassed compacted material; and
storing the cooled compacted material.

6. The method of claim 1, further comprising the step of performing a second crushing process of the crushed compacted material in the case where an average grain size of the crushed compacted material exceeds 30 mm.

5 7. The method of claim 1, further comprising the step of supplying nitrogen in each step.

 8. The method of claim 1, further comprising the steps of:
collecting dust particles generated in each step;
wet scrubbing the collected dust particles;
10 removing moisture from the wet scrubbed dust particles; and
discharging the dust particles from which moisture has been removed to the outside.

 9. A method for manufacturing molten iron, comprising the steps of:
producing hot fine direct reduced iron from fluidized beds;
15 charging the fine direct reduced iron to at least one pair of roller presses;

 roll pressing the fine directed reduced iron through the one pair of roller presses to produce continuous compacted material having grooves formed on pressed surfaces;
20 crushing the compacted material;
charging the crushed compacted material to a coal packed bed; and
supplying oxygen to the coal packed bed to manufacture molten iron,
wherein in the producing compacted material, from a cross section where the compacted material is cut along a lengthwise direction thereof that
25 is perpendicular to an axial direction of the roller presses, a groove of a second surface is positioned between two adjacent grooves of a first surface.

 10. The method of claim 9, wherein a ratio of an arc length between corresponding point of the first surface corresponding to a groove of the second surface and at least one groove of the adjacent grooves of the first surface, to an arc length between adjacent grooves of the first surface is
30 between 0.3 and 0.5.

11. The method of claim 9, further comprising the step of mixing hot calcined additives from multiple fluidized beds with the fine direct reduced iron and performing each step.

12. The method of claim 11, wherein the calcined additives are
5 3~20 wt% of the total compacted material.

13. The method of claim 11, wherein in the step of producing the compacted material, the fine direct molten iron is roll pressed at a temperature of 400~800°C by the one pair of roller presses.

14. The method of claim 11, wherein in the step of producing the
10 compacted material, the fine direct molten iron is roll pressed to 140~250 bar by the one pair of roller presses.

15. The method of claim 11, wherein in the step of producing the compacted material, the produced compacted material has a thickness of 3~30 mm and a density of 3.5~4.2 tons/m³.

16. The method of claim 11, wherein in the step of crushing the
15 compacted material, an average grain size of the compacted material is 50 mm or less, and the crushing performed produces irregular shapes.

17. The method of claim 16, wherein the average grain size of the compacted material is 30 mm or less.

18. The method of claim 11, wherein in the step of charging the
20 crushed compacted material to a coal packed bed, the compacted material with a grain size of 1~30 mm comprises 25~100 wt% of the total.

19. An apparatus for manufacturing molten iron, comprising:

25 a charge container receiving the supply of reducing material in which hot fine direct reduced iron and calcined additives from multiple fluidized-bed reactors are mixed;

at least one pair of roller presses to which the fine direct reduced iron is supplied to undergo roll pressing, thereby producing continuous compacted material;

30 a crusher crushing the compacted material produced by the roller presses; and

a melter-gasifier to which is charged crushed compacted material that is crushed by the crusher,

wherein concave grooves are uniformly and continuously formed along an axial direction of the at least one pair of roller presses on an outer surface thereof, and protrusions are formed between adjacent concave grooves along a circumferential direction of the roller presses; and

wherein the at least one pair of roller presses are formed such that a protrusion of a second roller press is positioned between two adjacent protrusions of a first roller press during producing the compacted material.

20. The apparatus of claim 19, wherein the charge container comprises:

a hollow chamber positioned above an area corresponding to between the press forming rolls;

an intake pipe connected to an upper portion of the hollow chamber and that supplies reducing material thereto; and

charge members mounted to both sides of the intake pipe making an acute angle with a vertical direction of the roller presses, and that are rotatably driven in this state such that reducing material in the hollow chamber is charged to the roller presses.

21. The apparatus of claim 19, further comprising:

a cooler for bypassing the crushed compacted material and cooling the same with water; and

a storage tank for transporting and storing the compacted material cooled by the cooler.

22. The apparatus of claim 21, wherein the cooler comprises:

a first conveyor that receives the crushed compacted material and submerges the compacted material in water to cool the same, then transmits the cooled compacted material to the storage tank; and

a second conveyor on which are mounted a plurality of blades that collect crushed compacted material powder that has collected on the floor, and that supply the powder to the storage tank.

23. The apparatus of claim 19, further comprising:

a hot separator for separating compacted material among the crushed compacted material with a grain size of 30 mm or more; and
an additional crusher for re-crushing the compacted material selected by the hot separator.

24. The apparatus of claim 23, further comprising a nitrogen supply device for supplying nitrogen to the additional crusher.

25. The apparatus of claim 19, further comprising a nitrogen supply device for supplying nitrogen to the roller presses and the crusher.

26. The apparatus of claim 19, wherein the roller presses are formed such that a ratio of an arc length between a corresponding point of the first roller press corresponding to a tip of a protrusion of the second roller press and at least one tip of protrusions of the first roller press, to an arc length between the tips of adjacent protrusions of the first roller press, is between 0.3 and 0.5.

27. The apparatus of claim 19, wherein the roller presses further comprise a hydraulic press unit, and the first roller press undergoes rotation in a stationary position while the second roller press may be varied in position to adjust an interval with the first roller press by the hydraulic press unit.

28. The apparatus of claim 19, further comprising:

a dust collecting port collecting dust particles generated in the charge container, and by the roller presses and the crusher;

a wet scrubber for wet scrubbing dust particles collected at the dust collecting port; and

a dehumidifier for removing the moisture from the dust particles that are wet scrubbed by the wet scrubber.

29. The apparatus of claim 19, wherein the compacted material produced by the pressed forming rolls has a thickness of 3~30 mm and a density of 3.5~4.2 tons/m³.

30. The apparatus of claim 19, wherein an average grain size of the

crushed compacted material is 50 mm or less, and crushing is performed to irregular shapes.